

Friday, April 07, 2017 12:35:32 PM

Page 1

Quality Control

Work Order ID 159324

Friday, April 07, 2017 12:35:32 PM

159324

Page 2

Item ID: D5238-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Bracket, Fwd
Start Date: 4/10/2017 Start Qty: 10.00 ***10*** Cust Item ID: .
Required Date: 4/12/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St457</u>	0.00							
130									
Packaging	Memo	0.10							
Packaging									
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							
Quality Control									

16 9-89 DAS APR 20 2017

17/4/24 JF

DAS 21 9-89 APR 21 2017

Picklist Print

Friday, April 07, 2017 12:35:36 PM

Page 1

Work Order ID: 159324

159324

Parent Item: D5238-045

D5238-045

Parent Item Name: Lower Bracket, Fwd

Start Date: 4/10/2017

Required Date: 4/12/2017

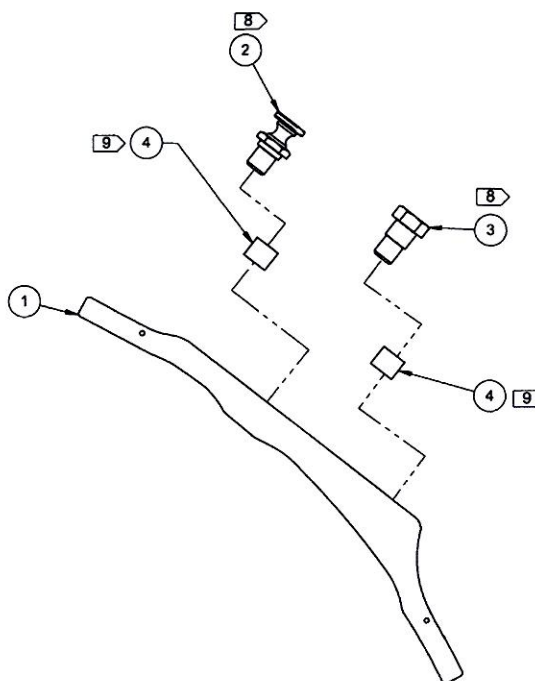
Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 15.05.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5237-3 *D5237-3* Bracket		Manufactured	No			100	Each	0.0000	1	10		APR 20 2017	DAS 6
									**	158637			
D5245-3 *D5245-3* Mounting Bolt		Manufactured	No			100	Each	9.0000	1	10		APR 20 2017	DAS 6
									**				
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				158937 x 7			
				GA	9					9			
				144777	9					10 16			
D5245-5 *D5245-5* Mounting Bolt		Manufactured	No			100	Each	9.0000	1	10		APR 20 2017	DAS 6
									**				
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				158930 x 7			
				GA	9					9			
				156698	9					20			
MS21209-F610 *MS21209-F610* Heli-Coil		Purchased	No			100	Each	57.0000	2	20		APR 20 2017	DA 6
									**				
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				27 x 4			
				ST296	57								
				m134294	7								
				m136199	50								

ITEM	QTY	P/N	DESCRIPTION
	X	D5238-045	LOWER BRACKET. FWD
1	1	D5237-3	BRACKET
2	1	D5245-3	MOUNTING BOLT
3	1	D5245-5	MOUNTING BOLT
4	2	MS21209F6-10	HELI-COIL, LOCKING



D5238-045 LOWER BRACKET. FWD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.52 lbs
- 8) TORQUE UP TO 160-190 in-lb (18.1-21.5 N-m)
- 9) INSTALL FLUSH WITH SURFACE, MAX 0.030" DEEP

RELEASED
2015-12-07

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5238	SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MAINTENANCE STEP ASSY	NTS
DATE	15.10.16	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	